

Work Order ID 50915

July 24, 2009 4:09:20 PM



Page 1

Item ID: D3875-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 07/27/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

BB 09/07/29 x3

M 111588

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435
Dwg Rev: *A*
Folio Rev: *A*

BB 09/07/29 (x3)

(P70)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05.05.12	W/O header	Added dms D 38 75 : Rev. A to dms box perm change	PC	09.08.14		05.05.12	05.05.12	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50915

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Page 2

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Required Date: 08/03/2009 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/07/29 X3

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB 09/08/05 X3

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

BB 09/08/05 X3

W/O:		WORK ORDER CHANGES					
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Item ID: D3875-1

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Setup Start



Revision ID: A

Stop



Item Name: Floor Protector

Start Date: 07/27/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

BB 09/08/05 (23)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S or 08/06

(8) p

170

Identify as per dwg & Stock Location: *pkny*

0.00



Packaging

Memo

0.00

Packaging

9/8/7 3084

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Revision ID: A

Item Name: Floor Protector

Start Date: 07/27/2009 Start Qty: 3.00

Required Date: 08/03/2009 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09-08-12
MF 09-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July 24, 2009 4:09:20 PM

Page 1

Work Order ID: 50915

Parent Item: D3875-1RevA

Parent Item Name: Floor Protector

Comments:

Start Date: 07/27/2009

Required Date: 08/03/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	600.0000	29.5200			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

111588

600

1111588 BB 07/08/05 X3

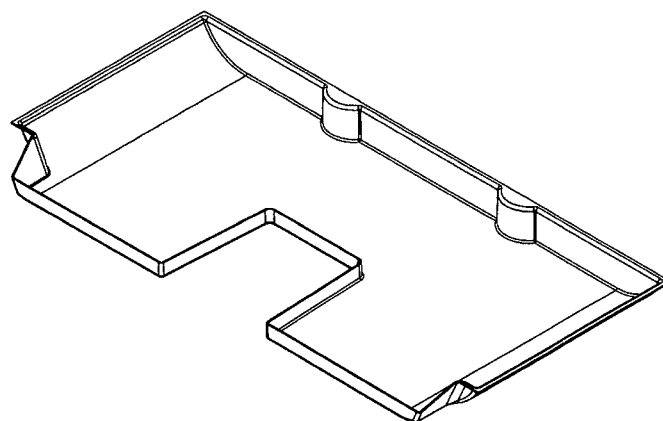
W/O:		WORK ORDER CHANGES					
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D3875-1 FLOOR PROTECTOR (206B)

#50915

RELEASED
29/05/05 MB

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	LL	DRAWING NO.	REV. A
MFG. APPR.	TS	D3875	SHEET 1 OF 2
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	FLOOR PROTECTOR (206B)	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

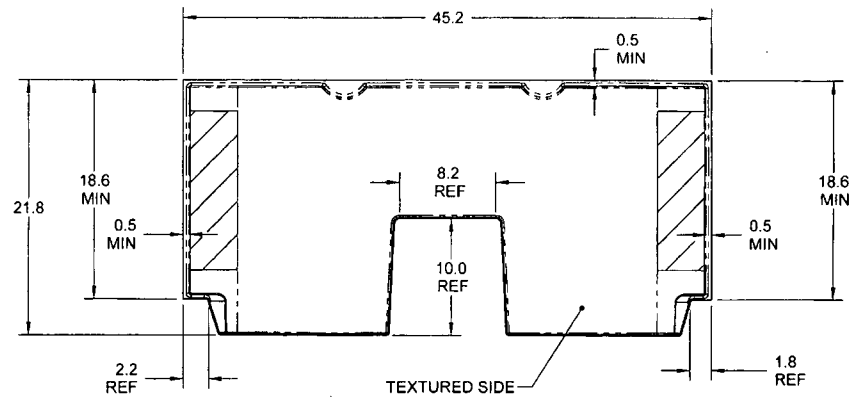
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8 7 6 5 4 3 2 1

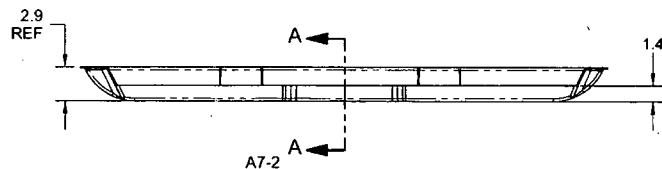
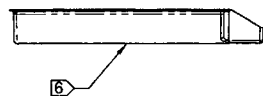
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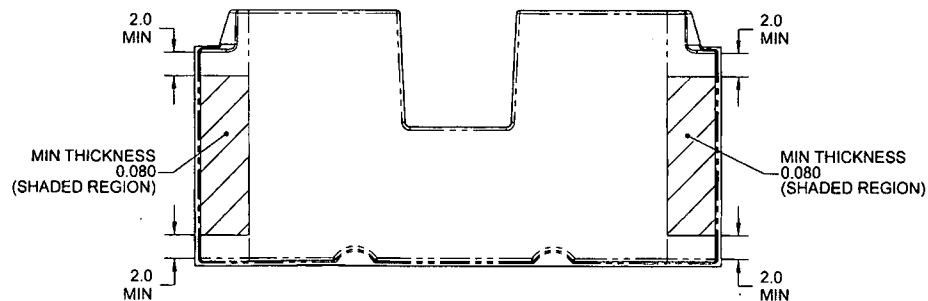
C

C



B

B



A

A

SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

50915

RELEASED
09/05/05

DESIGN	REV	DART AEROSPACE LTD	
DRAWN	REV	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REV	DRAWING NO.	REV. A
MFG. APPR.	REV	D3875	SHEET 2 OF 2
APPROVED	REV	TITLE	SCALE
DE APPR.	REV	FLOOR PROTECTOR (206B)	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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DART AEROSPACE LTD	Work Order:	50915
Description:	Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB Date: 09/08/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.050	Min	.053	✓			
.080	Min	.101	✓			
45.2	±.100	45.25	✓			
21.8	±.100	21.9	✓			
1.4	±.100	1.425	✓			

Measured by: JB Date: 09/08/05
Audited by: S Date: 09/08/05
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	